

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009421**Date Inspected:** 16-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG Components				

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

observations relative to the work being performed.

Ultrasonic Testing(Gate To Gate)

The QA Inspector performed, gate to gate Ultrasonic Testing (UT) on Orthotropic Box Girder deck plates to closed rib welds at the tack weld locations. The QA Inspector generated a field inspection UT report on this date designating areas of rejectable indications. Panel identification numbers are DP-330-002.

The Y locations of indication for the panel were marked and recorded as:

DP-330-002

Total Number of Ribs -04

Total Number of Tack Welds -152

Total Number of Tack Welds Scanned -152

Weld 01: Tack Welds Scanned - 19, Indication Observed - 18

Weld 02: Tack Welds Scanned - 19, Indication Observed - 09

Weld 03: Tack Welds Scanned - 19, Indication Observed - 04

Weld 04: Tack Welds Scanned - 19, Indication Observed - 02

Weld 05: Tack Welds Scanned - 19, Indication Observed - 06

Weld 06: No Indication

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Weld 07: Tack Welds Scanned - 19, Indication Observed – 02

Weld 08: Tack Welds Scanned - 19, Indication Observed – 01

Segment 5AW

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Deck Plates. The weld designations reviewed are as follows:

-(SEG021*001,002)

Segment 4AE

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Deck Plates. The weld designations reviewed are as follows:

-(SSD19-PP24-002/009)

-(SSD19A-PP24-002/003/007)

-(SSD20-PP25-002/003/009)

-(SSD20A-PP24-002/003/007)

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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